

Page 1.

DAS
44 15/02/25
~~9-89~~

DAS
44 15/02/85
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128956***128956***

Page 3

Tuesday, January 27, 2015 7:55:16 AM

Item ID: D2933-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206 Saddle Left
Start Date: 1/26/15 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 1/26/15 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160	QC3- Inspect Part Finish	0.00				<u>6</u>			DAS 38 9-89
160									
QC	Memo	0.00							
Quality Control									MAR 04 2015

170	Identify as per dwg & Stock Location: <u>St 396</u>	0.00				<u>6</u>			
170									
Packaging	Memo	0.00							
Packaging									MAR 04 2015 DAS 86 9-89

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									MLJ 15-03-05

15-3-5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Handling/Pre									
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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, January 27, 2015 7:55:15 AM

Work Order ID: 128956

128956

Parent Item: D2933-1

D2933-1

Parent Item Name: 206 Saddle Left

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001		Manufactured	No			100	Each	53.0000	1	6			
D6101-001									**		DAS		
Saddle Billet											44	15/02/25	
											9-89		

Location

Loc Qty

Loc Code

MAT042

13

*114353

5

124413

8

MAT045

40

*115128

10

122672

10

125829

20

1

5

DQA: _____ Date: _____



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FAULT CATEGORY

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DART AEROSPACE LTD		Work Order:	128956
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933	Rev: C	DSK:	Rev:
			Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.124	.123	.123	.123	.122
B	0.100	0.140		.121	.124	.123	.124	.124
C	0.100	0.140		.111	.110	.126	.119	.119
D	0.210	0.230		.220	.223	.223	.223	.223
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.513	.513	.513	.513	.513
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	.258	.258	.258
L	0.312	0.317		.314	.314	.314	.314	.314
M	0.235	0.240		.237	.236	.237	.237	.235
N	0.100	0.140		.119	.121	.121	.120	.120
O	0.540	0.560		.549	.548	.547	.547	.548
P	0.490	0.510		.500	.494	.493	.498	.496
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.494	2.493	2.493	2.493	2.493
S	0.240	0.270		.251	.249	.248	.248	.248
T	0.100	0.180		.135	.140	.140	.140	.140
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.125	1.145		1.135	1.138	1.1373	1.1375	1.137
Y	1.565	1.585		1.573	1.573	1.5753	1.5754	1.575
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: F.X.	Date: 15-02-26	Date: 15/02/25
Audited by: [Signature]	Date: 15/02/27	
Prototype Approval: N/A	Date: N/A	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

DART AEROSPACE LTD		Work Order:	128956
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1	

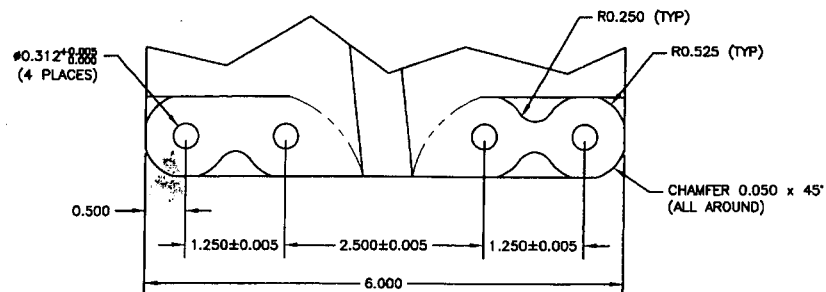
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	3	4	5	
A	0.100	0.140		.123				
B	0.100	0.140		.123				
C	0.100	0.140		.119				
D	0.210	0.230		.223				
E	1.245	1.255		1.250				
F	1.245	1.255		1.250				
G	2.495	2.505		2.500				
H	0.510	0.515		.513				
I	1.572	1.582		1.572				
J	2.495	2.505		2.500				
K	0.257	0.262		.258				
L	0.312	0.317		.314				
M	0.235	0.240		.235				
N	0.100	0.140		.121				
O	0.540	0.560		.547				
P	0.490	0.510		.495				
Q	3.715	3.725		3.720				
R	2.470	2.510		2.493				
S	0.240	0.270		.248				
T	0.100	0.180		.140				
U	1.625	1.635		1.630				
V	1.362	1.372		1.367				
W	0.316	0.321		.316				
X	1.125	1.145		1.137				
Y	1.565	1.585		1.575				
Z	0.178	0.198		.188				
AA								
AB								
AC								
AD								
AE								
DAS Accept/Reject								

Measured by:	20 9-89	Date:	15-02-26
Audited by:	<i>[Signature]</i>	Date:	15/02/27
Prototype Approval:	N/A	Date:	N/A

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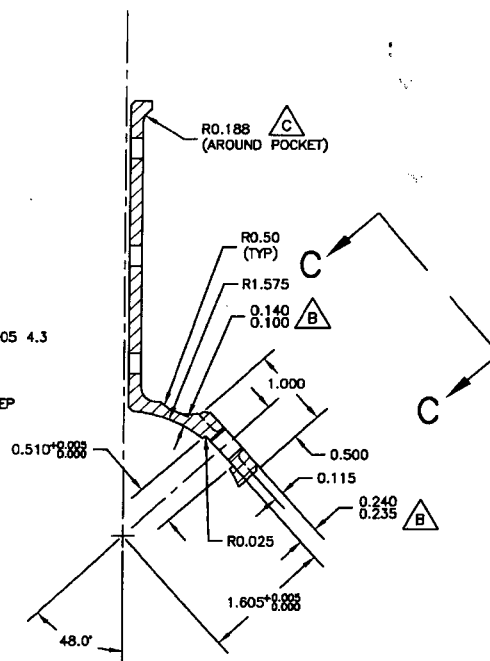


VIEW C-C

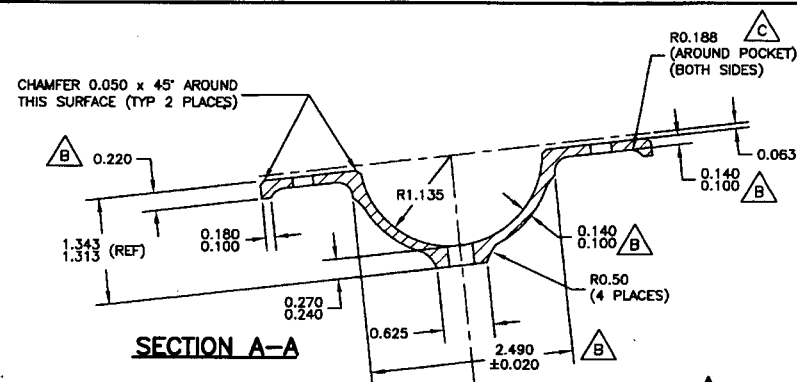
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

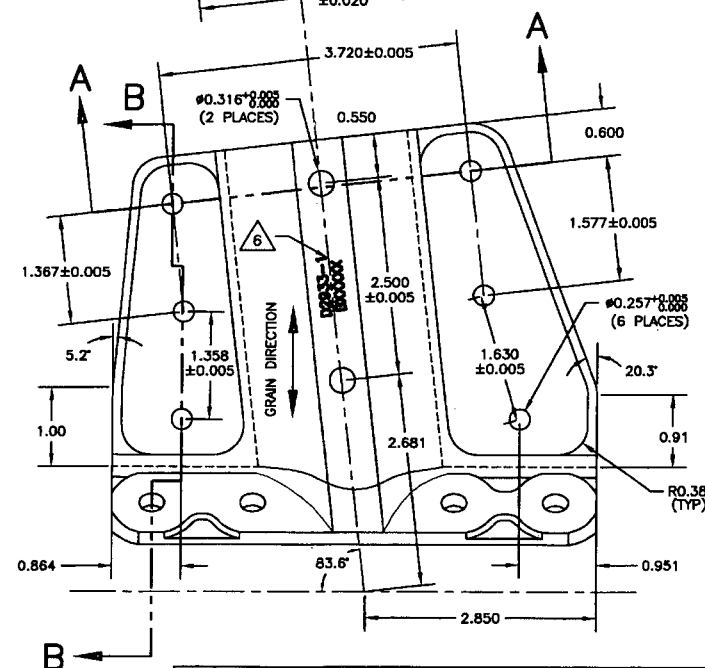
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	DRAWING NO. D2933
		TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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DART DART AEROSPACE USA, INC.
 BELLEVILLE, ILL.

FILED
 07.02.12